

Date: Wednesday, 13/08/2008 12:40:10 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 41221		
Estimate Number	: 11301		
P.O. Number	:	Part Number	: D34475
This Issue	: 13/08/2008 S.O. No. :	Drawing Number	: D3447REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 13/08/2008 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 39967	Material	:
Written By	:	Due Date	: 15/09/2008
Checked & Approved By	: <u>JUL 08 8.13</u>	Qty:	15 Um: Each
Comment	: A A 05.08.26 New issue KJ/JLM Est Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R1000	ROUND BAR 1.00"
Comment: Qty.: 0.3325 f(s)/Unit Total : 1.9952 f(s) ROUND BAR 1.00" Material: 6061-T6 Bar Ø1.00 (QQ-A-200/8 or QQ-A-225/8) (M6061T6R1.000) Identify for D3447-5 Batch: <u>118147</u>		
2.0	DOOSAN LATHE	DOOSAN LATHE
Comment: DOOSAN CNC LATHE Turn as per Folio & Dwg B67-43001 Dwg Rev: <u>A</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL LATHE <i>will</i> Drill as per Dwg D3447 Deburr		
Tools: rill		
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 13/08/2008 12:40:10 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 41221

Part Number: D34475

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/08/24

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JA

08.08.25

(X15)

8.0

POWDER COATING

POWDER COATING



M102316



(15X)

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask 0.875" round section

START TIME:

10:00  
05

OVEN TEMPERATURE:

320

FINISH TIME:

10:30

M.J

08/08/26

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.08.26 (15)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 94

8/8/27

(15X)

SB

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/27 JA

Job Completion



u 08.08.27

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41221
<b>Description:</b> Clevis		<b>Part Number:</b> D3447-5
<b>Inspection Dwg:</b> D3447	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.78	+/-0.030	3.78				
2.500	+/-0.010	2.495				
Ø0.859	+0.000/-0.005	.857				
10°	+/-0.5°	10°				
0.380	+/-0.010	.375				
0.190	+/-0.010	.190				
0.442	+/-0.010	.445				
R0.50	+/-0.030	R.5				
0.125	+/-0.010	.125				
0.350	+/-0.010	.350				
Ø0.250	+0.005/-0.001	.2495				
10°	+/-0.5°	10°				
2.063	+/-0.010	2.063				
Ø0.250	+0.005/-0.001	.2495				
1.00	+/-0.030	1.000				

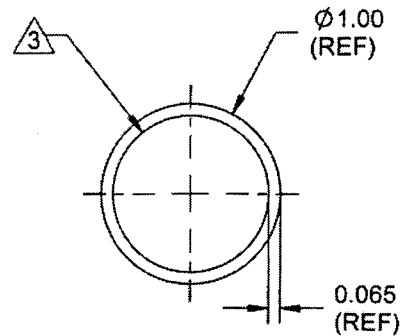
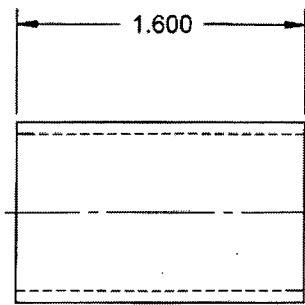
<b>Measured by:</b> 20	<b>Audited by:</b> J.L.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/08/24	<b>Date:</b> 08/08/24	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	08.07.24	New Issue	KJ/DD	DD

**DART**

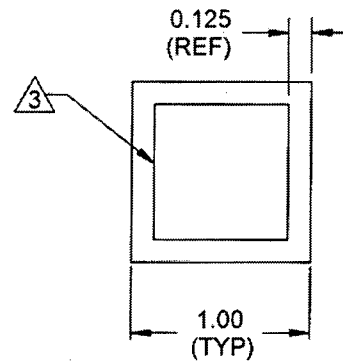
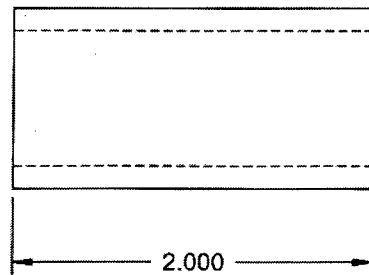
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3447</b>	REV. A SHEET 1 OF 4
DATE <b>05.07.19</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1
A	05.07.19	NEW ISSUE	

RELEASED  
05/08/18



#### **D3447-1 ROUND SPACER**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)



#### **D3447-3 SQUARE SPACER**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115/ 4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.000W.125)

#### **NOTES:**

- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK INSIDE OF TUBING BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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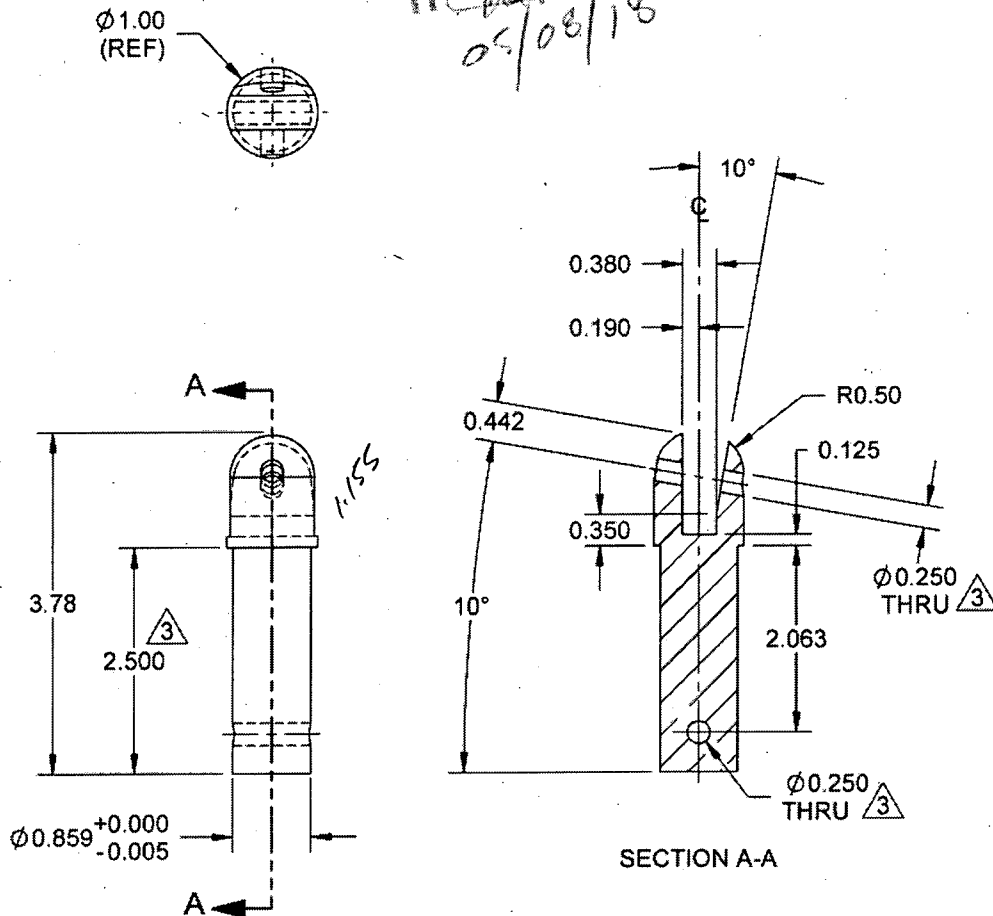
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DATE <b>05.07.19</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:2

RELEASED  
05/08/18



**D3447-5 CLEVIS**  
**SUPERSEDES PREMIER P/N B67-43001-99**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6R1.000)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

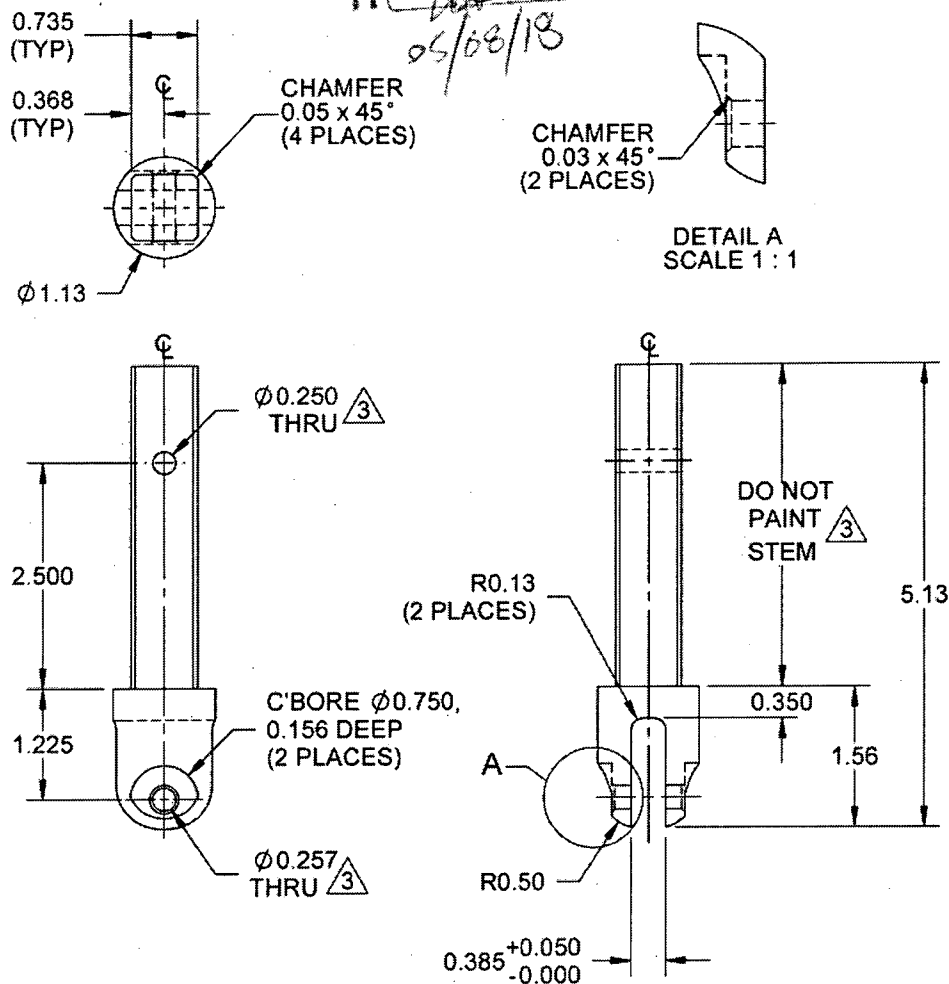
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DATE <b>05.07.19</b>	TITLE <b>BLADE FOLD KIT PARTS</b>		SCALE 1:2



**D3447-7 CLEVIS**  
**SUPERCEDES PREMIER P/N B67-43001-145/-345**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6R1.125)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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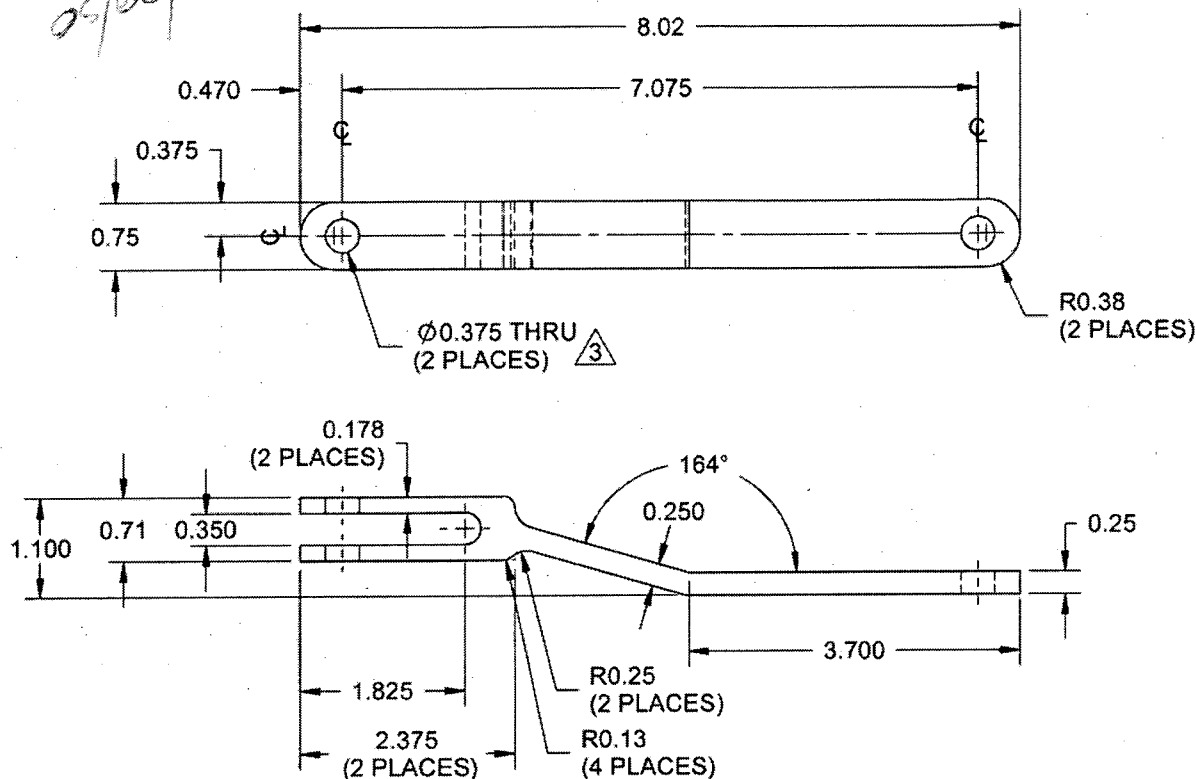
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DATE <b>05.07.19</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:2

RELEASED  
*[Signature]*  
05/08/18



**D3447-9 SWING ARM**  
**SUPERSEDES PREMIER P/N B67-43001-263**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) COVER INSIDE HOLES PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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